

Asap

Work Order ID 113925

February-27-14 7:48:27 AM

113925

Page 1

Item ID: D3405-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Gh Lug

Start Date: 2/27/14

Start Qty: 20.00

20 26
20

Cust Item ID:

Required Date: 3/07/14

Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3405	Rev B

100	FLOW WATER JET Waterjet FLOW CNC Waterjet 304 .125"	0.00	26	0	Jm 14-03-1
	Memo	0.00			
	1-Cut as per Dwg D3405 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary				

110	QC2- Inspect parts off machine FAI/FAIB QC Quality Control	0.00	26	0	Jm 14-03-1
	Memo	0.00			

120	QC8- Inspect parts - second check QC Quality Control	0.00	DAS 27 9-09 4/3/13	26	0	
	Memo	0.00				

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Page 3

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Start Date: 2/27/14

Start Qty: 20.00

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Cust Item ID:

Required Date: 3/07/14

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

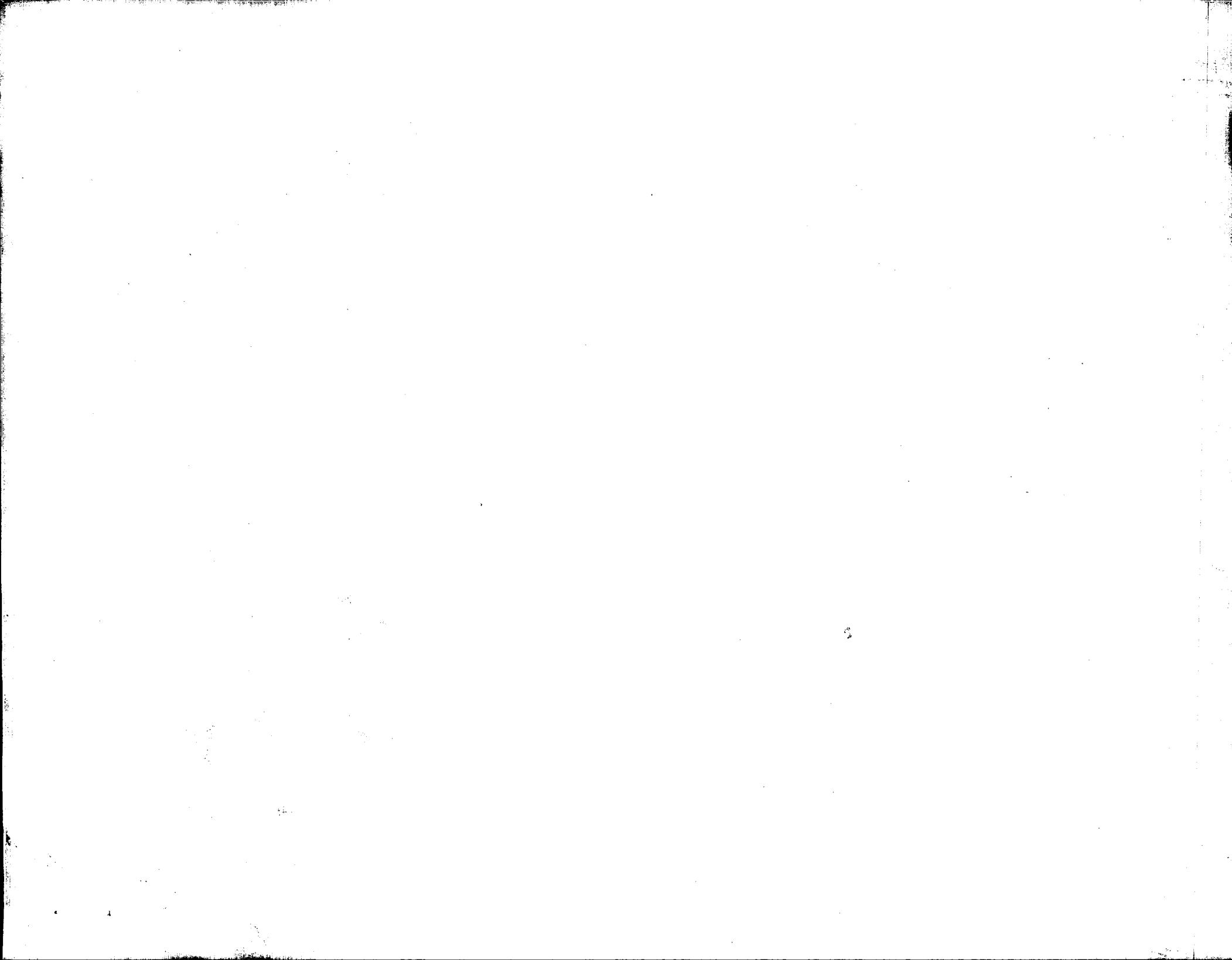
SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds	0.00							DAS 9 9-89
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9-89
180 *180* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel <i>M128021</i>	0.00							DAS 34 3-89
	Memo START TIME: <i>1:30</i> OVEN TEMPERATURE: <i>400°</i> FINISH TIME: <i>2:00</i>	0.00							



Work Order ID 113925

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Page 4

Item ID: D3405-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Gh Lug

Stop

NS2

Start Date: 2/27/14

Start Qty: 20.00

20

Cust Item ID:

Required Date: 3/07/14

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00

100

QC

Quality Control

26

SAO

14/03/11

200

Identify as per dwg & Stock Location:

0.00

DAS
32
9-89***200***

Packaging

Packaging

Memo

57468

0.00

14/3/11 (26)

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Quality Control

Memo

0.00

14/03/18

D4-03-17

Picklist Print

February-27-14 7:48:26 AM

Page 1

Work Order ID: 113925

113925
D3405-041

Parent Item: D3405-041

Parent Item Name: Gh Lug

Start Date: 2/27/14

Required Date: 3/07/14

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A05.09.01 New issue KJ/JLM
IPP B 09.01.28 rev.B drawing EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3404-1		Manufactured	No		100	Each	14.0000	1	20				
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D3404-1

GHW/ Lug

B110801 x 26

M304S11GA

M304S11GA

304/316 0.125 Sheet

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
			WA001	14		
			108099	3		
			110307	11		

			sf	236.5600	0.154	4
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**

Jn 14-03-1

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
			MAT020	236.56		
			122521	36		
			M126075	8.56		
			M128254	192		

126075
128

DART AEROSPACE LTD	Work Order:	113925
Description: GHW Lug	Part Number:	D3405-1
Inspection Dwg: D3405	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

DAS

Measured by:	Jm	Audited by:	27 9-89	Prototype Approval:	N/A
Date:	14-03-1	Date:	14/3/3	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.28	New Issue P/O D3405-041	KJ/EC	
B	09.05.04	Dimensions update per Dwg Rev. B	KJ/DD	

D

D

C

C

B

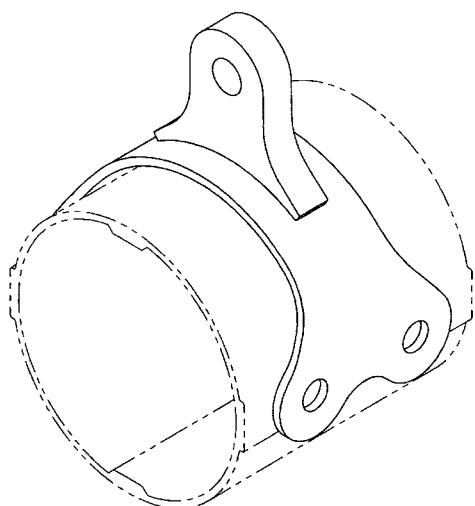
B

A

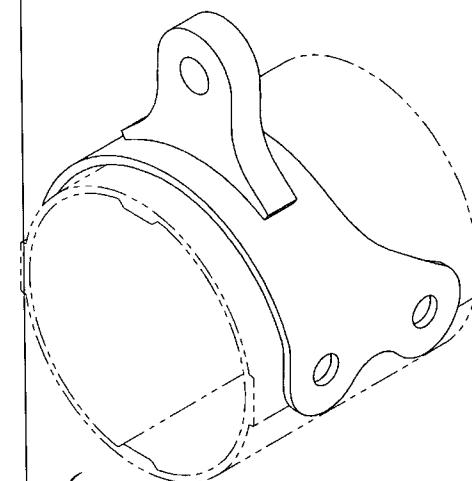
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ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET

B



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

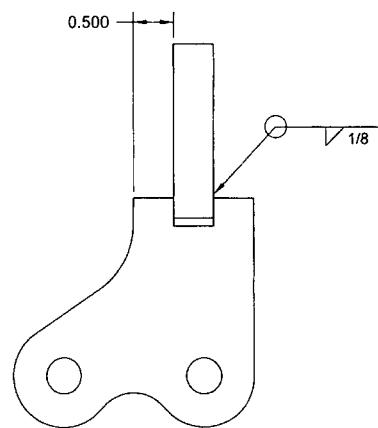
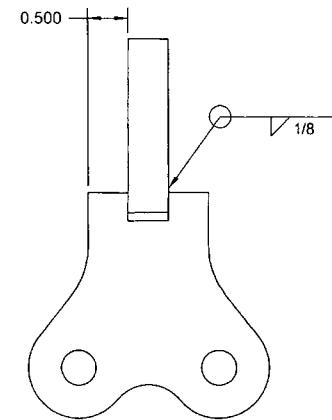
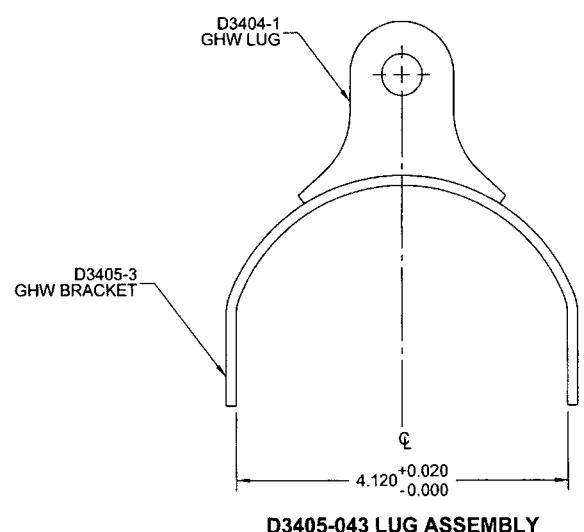
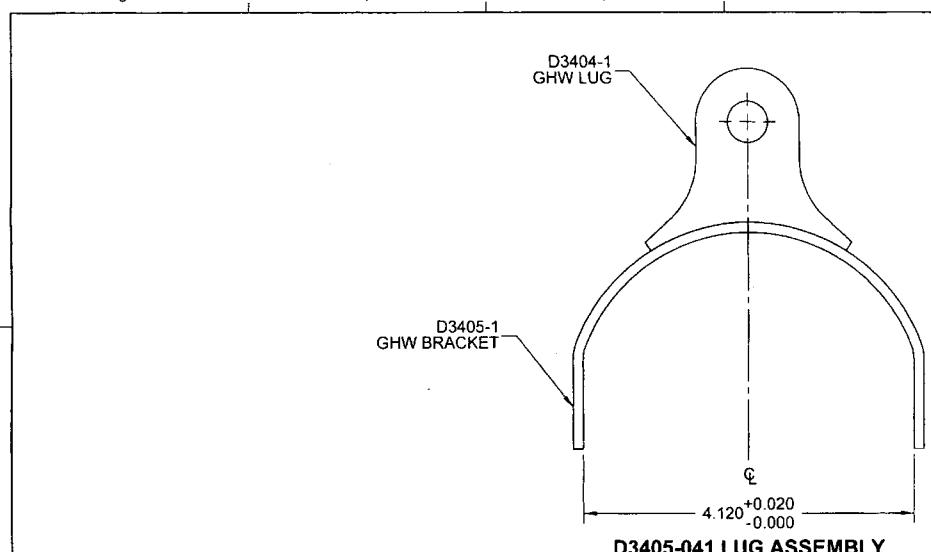


D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL. (SEE PAR198). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100.			AJS	08.09.19
A	NEW ISSUE			PH	05.03.08
REV.	DESCRIPTION			BY	DATE
DESIGN	PH	DART AEROSPACE LTD			
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA			
CHECKED		DRAWING NO. D3405			REV. B
MFG. APPR.		TITLE			SHEET 1 OF 4
APPROVED		SCALE			
DE APPR.		GHW LUG ASSEMBLY			NTS
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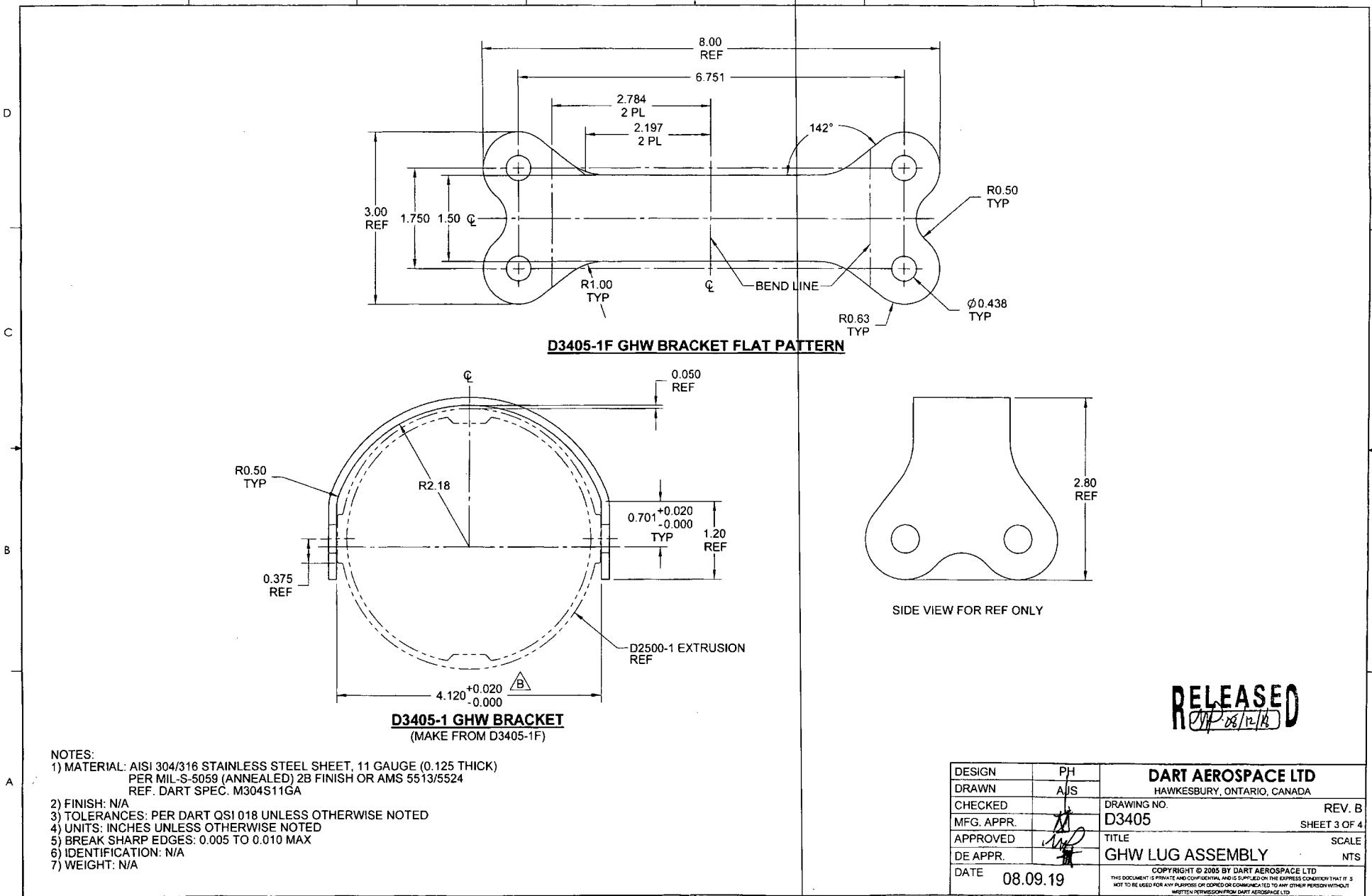


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MFG. APPR.		D3405	SHEET 2 OF 4
APPROVED		TITLE	
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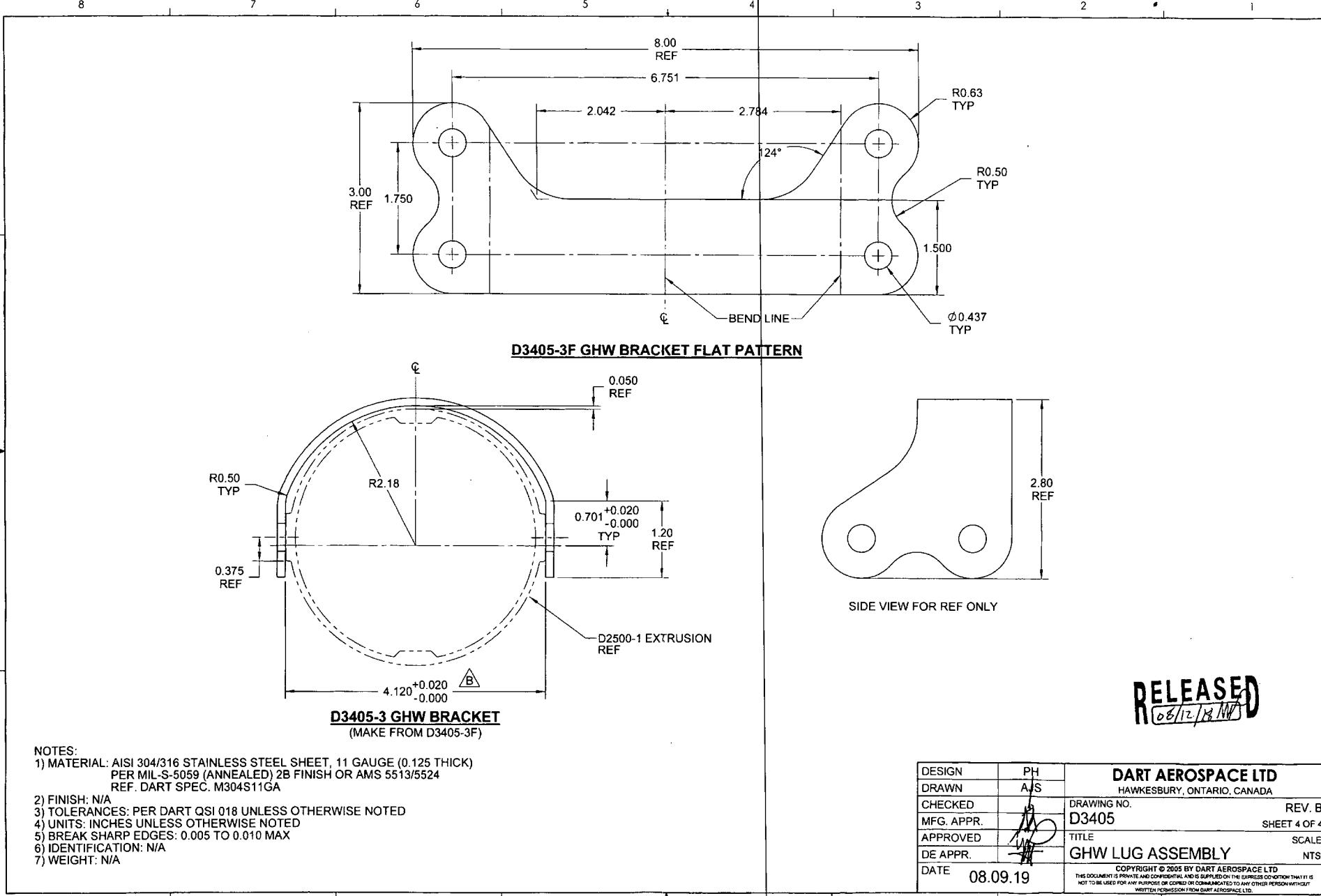
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
		D3405	SHEET 3 OF 4
MFG. APPR.	<i>M</i>	TITLE	SCALE
APPROVED	<i>M</i>	GHW LUG ASSEMBLY	NTS
DE APPR.	<i>M</i>		
DATE	08.09.19		

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2017-08-12/18

8 7 6 5 4 3 2 1





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